

Date: Tuesday, 10/06/2008 8:52:03 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: DOOR PANEL		
Job Number	: 39744			Part Number	: D32961		
Estimate Number	: 11401			Drawing Number	: D3296 REV A		
P.O. Number	:			Project Number	: N/A		
This Issue	10/06/2008	S.O. No.	:	Drawing Revision	: A		
Prsht Rev.	: NC			Material	:		
First Issue	/: /	Type	: SMALL /MED FAB	Due Date	: 17/06/2008		
Previous Run	: 37038			Qty:	15	Um:	Each
Written By	:						
Checked & Approved By	JL 08.06.10						
Comment	: Est C 05.10.14 Added step 14 KJ/EC						
	Est Rev:D Now on Waterjet 06-11-02 JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S063	2024-T3 .063 sheet 108415
		Comment: Qty.: 0.6926 sf(s)/Unit Total : 10.3887 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.063" thick (M2024T3S.063) Identify for D3296-1 Batch: 108415 108415 MAT NOT PULLED
2.0	WATER JET	FLOW WATER JET 108415
		Comment: FLOW WATER JET 1-Cut as per Dwg D3296 Dwg Rev: <u>A</u> 108415 Prog Rev: <u>A</u> 108415 16
		2-Deburr if necessary 108415
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 108415
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK 108415
		Comment: SECOND CHECK S 08/07/02 K16
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 108415
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr a/ Done at \$16 \$22 S 08/07/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: DOOR PANEL

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1. HAND FINISHING RESOURCE #1



16X

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-1 08/07/02

7.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



S 08/07/02 x16

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0 PACKAGING 1 PACKAGING RESOURCE #1



16X

Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: 180

8/7/2

SD

9.0 QC21 FINAL INSPECTION/W/O RELEASE



08/07/03

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-07-03

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DART AEROSPACE LTD	Work Order:	39744
Description: Door Panel	Part Number:	D3296-1
Inspection Dwg: D3296	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: B	Audited by: J	Prototype Approval: N/A
Date: 8-7-2	Date: 08/07/02	Date: N/A

Rev	Date	Change	Revised by	Approved
A	04.08.24	New Issue	P/O D3296-041	KJ/JLM <i>[Signature]</i> <i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

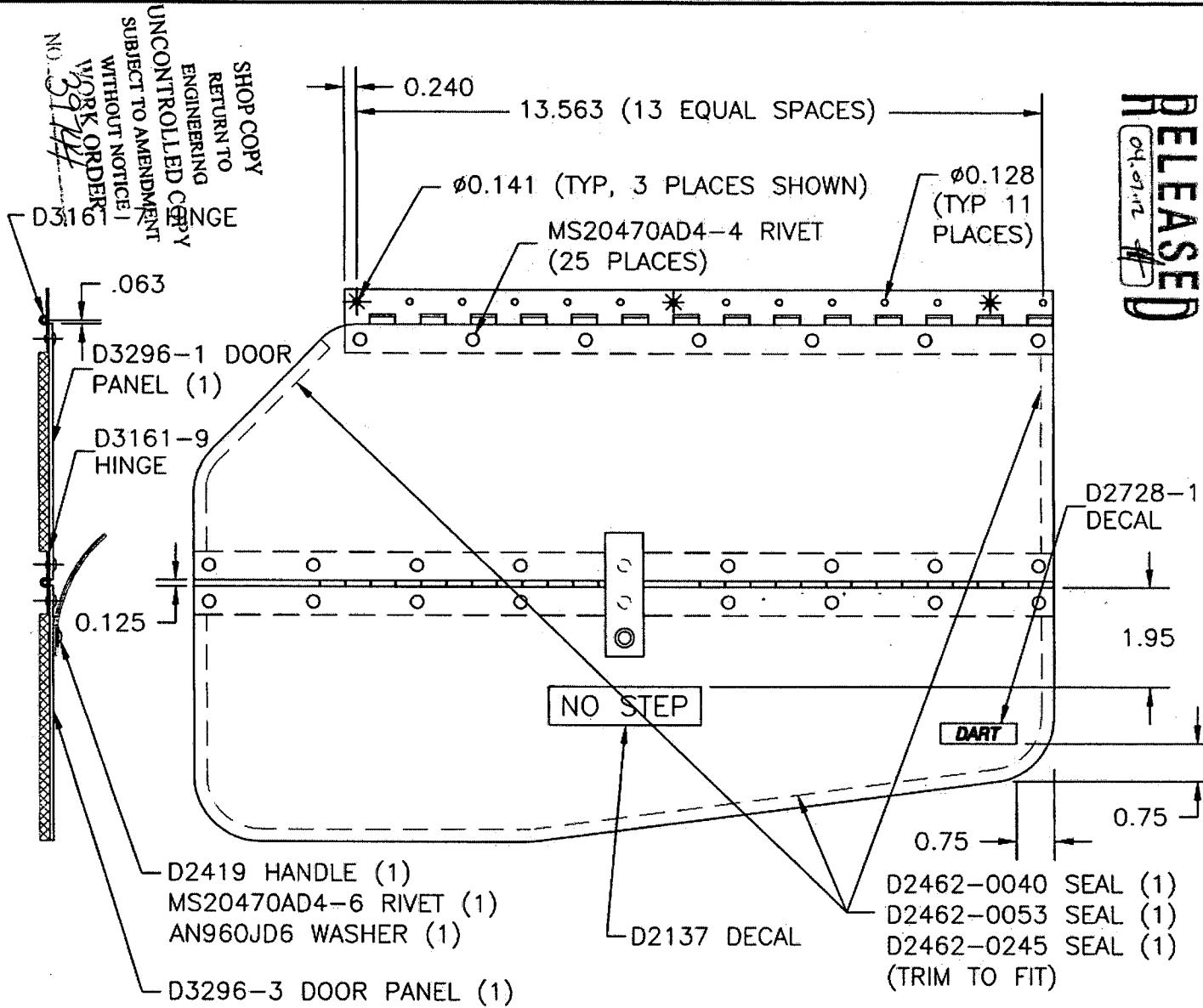
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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D3296-041 DOOR ASSEMBLY

- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
- 2) FINISH: POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART
04.06.28

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04.06.28

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CHECKED	APPROVED	DRAWING NO.
		D3296
DATE	DATE	REV. A
04.06.28	04.06.28	1 OF 2
TITLE	TITLE	SCALE
DOOR ASSEMBLY	DOOR ASSEMBLY	1:3
A	04.06.28	NEW ISSUE

W/O:		WORK ORDER CHANGES					
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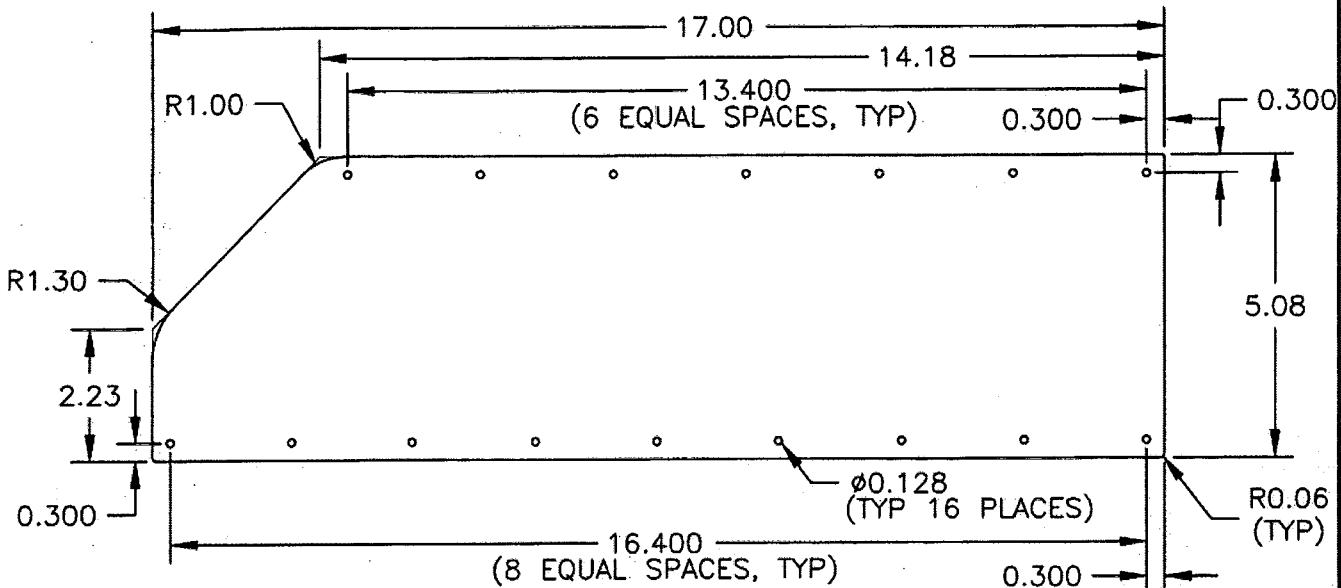
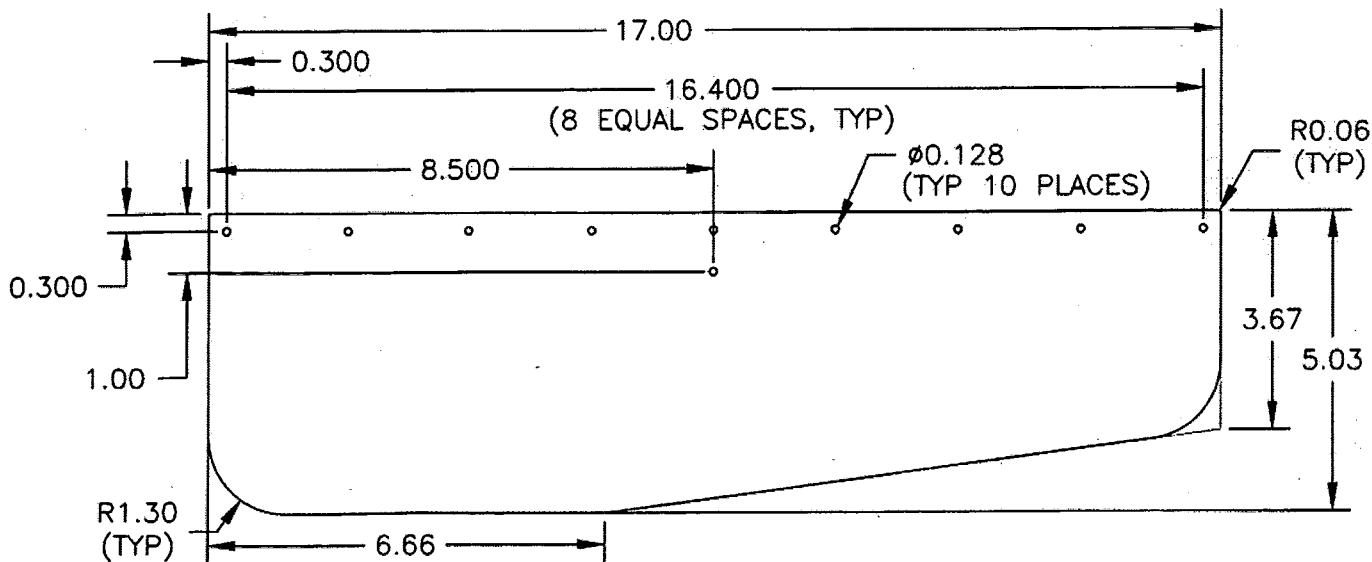
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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		HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3296	2 OF 2
DATE		TITLE	SCALE
04.06.28		DOOR ASSEMBLY	1:3

D3296-1 DOOR PANELD3296-3 DOOR PANELD3296-1 AND D3296-3

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK
(REF DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
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